

Dart Aerospace Ltd.

Date: Tuesday, 22/04/2008 12:36:15 PM
User: Linda Lacella

Process Sheet

Eagle 44255

Proj C S/m/p2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY
Job Number	: 37383	Part Number	: D412711011
Estimate Number	: 10902	Drawing Number	: N/A
P.O. Number	:	Project Number	: N/A
This Issue	: 22/04/2008	Type	: PURCHASED PARTS
Prsh't Rev.	: NC	Drawing Revision	: N/A
First Issue	: 12/02/2008	Material	: N/A
Previous Run	: 36802	Due Date	: 28/02/2008 Qty: 1 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev A 04.08.18 New Issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		Comment: DOCUMENT CONTROL Photocopy bluefiles and create labels per PPP D412-711-011 CHG001
2.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>5687</u> to Eagle Copters "Assembly of D412-711-011 Door Send a copy of this IPP
3.0	D412711041	Vertical Reference Door Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Vertical Ref. Door Assy
4.0	D412711101	Replacement Bubble Window
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
5.0	D412711111	Wiring Harness, 212/412
		Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s) Pick: Packing Kit Qty Part Number Description Batch <i>Not Required</i> 1 D412-711-111 Wiring Harness, 212/412 <u>w644500</u> Apr 21/08

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 37383

Part Number: D412711011

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 EA20469-15-412 Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412 w/44499

Not Required

Apr 21
2008

7.0 OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick: Qty Part Number Description Batch
1 204-030-853-119 LH Co-pilot Door %44255

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
1	EB212-100L / EA20469-3	Window	08-001222
1	EA20469-05	Rubber Strip	06-011664
1	EA20469-06	Aluminum Strip	<u>Deleted</u>
1	EA20469-07	Angle	_____
1	EA20469-08	Placard	_____
1	EA20469-10	Rear Rib Assy	_____
1	EA20469-11	Angle	_____
1	EA20469-12	Fwd Rib	_____
1	EA20469-13	Window	_____
1	EA20469-14	Window Retainer	_____
1	EA20469-16	Armrest Assy	_____
1	EA20469-17	Angle	_____
1	EA20469-18	Door Inner Skin	_____
1	EA20469-21	Door Cover Panel	_____
2	EA20469-23	Link	_____
1	EA20469-24	Rod	_____
1	EA20469-25	Arm Assy	_____

{ w/44499 }

Material Certification / Proof of Traceability / Certificate of Conformity required

PART NUMBER: D4T2/11011

Job Number:		
Seq. #:	Machine Or Operation:	Description :
<p>3-EAGLE Pick: Qty Part Number Description Batch</p> <p>14 AN3-3ABolt <u>07-018790</u> 22 AN3-4ABolt <u>08-061209</u> 24 AN3-7ABolt <u>07-017476</u> 6 AN960-6L Washer <u>05-022623</u> 90 AN960-10L Washer <u>06-018522</u> 34 CR3242-4-2 Rivet <u>08-001645</u> 135MS20426AD3-3 Rivet <u>07-006985</u> 140MS20426AD4-3 Rivet <u>05-002460</u> 25 MS20470AD3-3 Rivet <u>07-007189</u> 90 MS20470AD4-3 Rivet <u>07-015056</u> 24 MS21042L3 Nut <u>08-002039</u> 2 MS21042L06 Nut <u>06-014775</u> 13 MS21069L3 Nut Plate <u>08-001202</u> 8 MS21069L08 Nut Plate <u>07-018940</u> 1 MS21071L3 Nut Plate <u>08-002216</u> 1 MS21071L08 Nut Plate <u>08-001935</u> 9 MS21075L3 Nut Plate <u>05-004764</u> 2 MS24677-12 Screw <u>05-011931</u> 6 MS27039-1-09 Screw <u>07-014232</u></p>		
<p>4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.</p> <p>5-Apply Dart P/N & B/N using fine point permanent marker</p> <p><i>BB Apr 2/08</i></p>		
8.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
<p><i>BB</i></p> <p>Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS Send this W/O back to DartKit to be stocked at Eagle</p>		
9.0	QC5	INSPECT WORK TO CURRENT STEP
<p><i>BB</i></p> <p>Comment: INSPECT WORK TO CURRENT STEP</p>		
10.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</p> <p><i>not required - Delivered to A/C</i></p>		

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 37383

Part Number: D412711011

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC21

FINAL INSPECTION/WO RELEASE



Comment: FINAL INSPECTION/WO RELEASE

D 08/04/29 (1)

Job Completion



U 08/04/29

Eagle Copters Maintenance Ltd

WORK REPORT

Work Order Number: 44401 V/Door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 L/H DOOR ASSEMBLY

Squawk: 1.1

Discrepancy:

Modify Door to Vertical Reference Door

Resolution:

Modified Door to Vertical Reference Door as per STC No. SH92-55 on Service order P/O 08-000514.1. Door assembled as required.

1.1 Work Done By: John Waite

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.

AMO 6-81 Signature: Colin Gould on 3/7/2008

Parts:

Part Number	Description	Lot Number	Condition	Qty
204-030-853-037A	SKIN ASSY	LT-07-010860.1	New	1
204-030-499-005	ROLLER ASSY	LT-08-001870	New	1
BELL212-L	BUBBLE WINDOW ILO EA20469-03 and D412-711-101	LT-08-001222	New	1
412-110-103	DOOR HANDLE W/LOCK	LT-07-018126.1	New	1

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

Squawk: 1.2

Discrepancy:

paint door

Resolution:

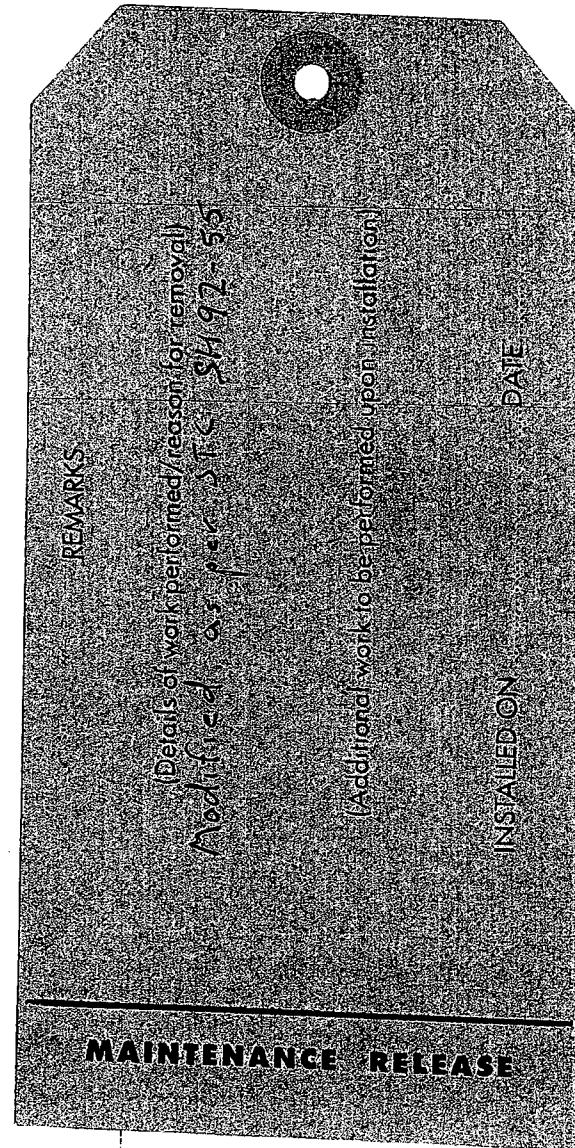
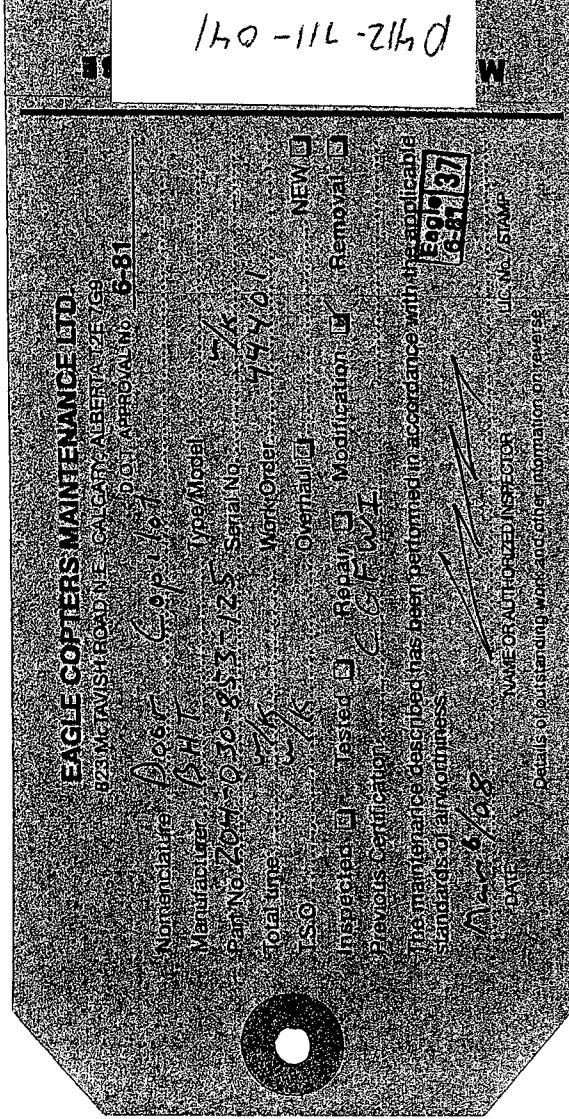
Door painted as required

1.2 Work Done By: Colin Gould

* End of Report *

***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****

***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****



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Job Number	37384			Part Number	: D412711011		
Estimate Number	10902			Drawing Number	: N/A		
P.O. Number	:			Project Number	: N/A		
This Issue	22/04/2008	S.O. No.	:	Drawing Revision	: N/A		
Prsht Rev.	NC			Material	: N/A		
First Issue	12/02/2008	Type	PURCHASED PARTS	Due Date	28/02/2008	Qty:	1
Previous Run	37383			Um:	Each		
Written By	<u>W</u>						
Checked & Approved By							
Comment	Est Rev:A 04.08.18 New Issue KJ/DS						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
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Comment: DOCUMENT CONTROL Photocopy bluefiles and create labels per PPP D412-711-011 CHG001			
2.0	PG	PURCHASING	
Comment: PURCHASING Issue P/O: <u>5687</u> to Eagle Copters "Assembly of D412-711-011 Door Send a copy of this IPP			
3.0	D412711041	Vertical Reference Door Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Vertical Ref. Door Assy			
4.0	D412711101	Replacement Bubble Window	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
5.0	D412711111	Wiring Harness, 212/412	
Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s) Pick: Packing Kit Qty Part Number Description Batch 1 D412-711-111 Wiring Harness, 212/412			

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Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	EA2046915412	Instrument Panel, 412
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 EA20469-15-412 Instrument Panel, 212/412 _____

7.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door _____

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window _____

1 EA20469-05 Rubber Strip _____

1 EA20469-06 Aluminum Strip _____

1 EA20469-07 Angle _____

1 EA20469-08 Placard _____

1 EA20469-10 Rear Rib Assy _____

1 EA20469-11 Angle _____

1 EA20469-12 Fwd Rib _____

1 EA20469-13 Window _____

1 EA20469-14 Window Retainer _____

1 EA20469-16 Armrest Assy _____

1 EA20469-17 Angle _____

1 EA20469-18 Door Inner Skin _____

1 EA20469-21 Door Cover Panel _____

2 EA20469-23 Link _____

1 EA20469-24 Rod _____

1 EA20469-25 Arm Assy _____

Material Certification / Proof of Traceability / Certificate of Conformity required

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Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #: Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
14	AN3-3ABolt		
22	AN3-4ABolt		
24	AN3-7ABolt		
6	AN960-6L Washer		
90	AN960-10L Washer		
34	CR3242-4-2 Rivet		
135	MS20426AD3-3 Rivet		
140	MS20426AD4-3 Rivet		
25	MS20470AD3-3 Rivet		
90	MS20470AD4-3 Rivet		
24	MS21042L3 Nut		
2	MS21042L06 Nut		
13	MS21069L3 Nut Plate		
8	MS21069L08 Nut Plate		
1	MS21071L3 Nut Plate		
1	MS21071L08 Nut Plate		
9	MS21075L3 Nut Plate		
2	MS24677-12 Screw		
6	MS27039-1-09 Screw		

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

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Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #:	Machine Or Operation:	Description :
11.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

